

Date: Wednesday, 2/20/2008 4:27:42 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	WEARSHOE		
Job Number	37561		Part Number	D356413		
Estimate Number	12788		Drawing Number	D3564 REV D		
P.O. Number			Project Number	N/A		
This Issue	2/20/2008	S.O. No. :	Drawing Revision	D		
Prsht Rev.	NC		Material			
First Issue	/ /	Type : SMALL /MED FAB	Due Date	3/18/2008	Qty:	20
Previous Run	37239		Um:	Each		
Written By	<u>KC</u>					
Checked & Approved By	<u>KC 08.02.21</u>					
Comment	Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.2331 sf(s)/Unit Total : 4.6620 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>iC6860</u> <u>IB 8-2-25</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3564 Dwg Rev: <u>D</u> <u>IB 8-2-25</u> <u>(22)</u> Prog Rev: <u>D</u>		
2-Deburr if necessary <u>IB 8-2-25</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>IB 8-2-25</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<u>IB 8-2-25</u> <u>(22)</u>		
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT and DT		
<u>IB 8-2-25</u> <u>9155</u> <u>SB 08/03/17</u> <u>(22)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/03/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:27:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 37561

Part Number: D356413

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

08/03/08 (22)

7.0 POWDER COATING

POWDER COATING



N106442

(22)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m/ 08/03/18

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



el

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-18 (X22)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-21

el

08-03-18

(X22)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(22)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/19

Job Completion



~ 2008/3/18

(22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

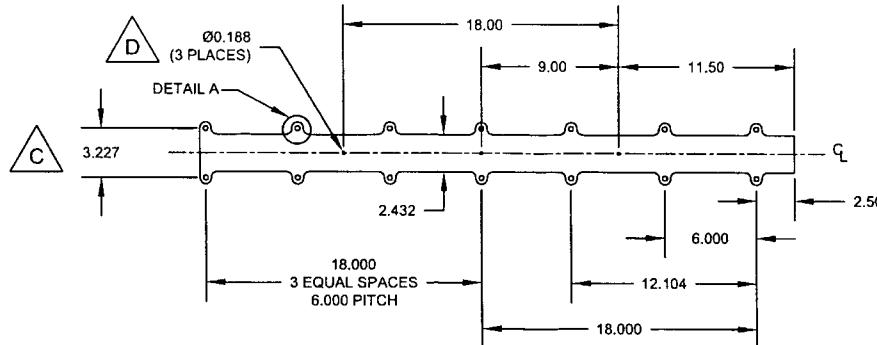
DART AEROSPACE LTD	Work Order:	37561
Description: Wearshoe	Part Number:	D3564-13
Inspection Dwg: D3564	Rev: <i>e</i> D P4 07-02-21	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

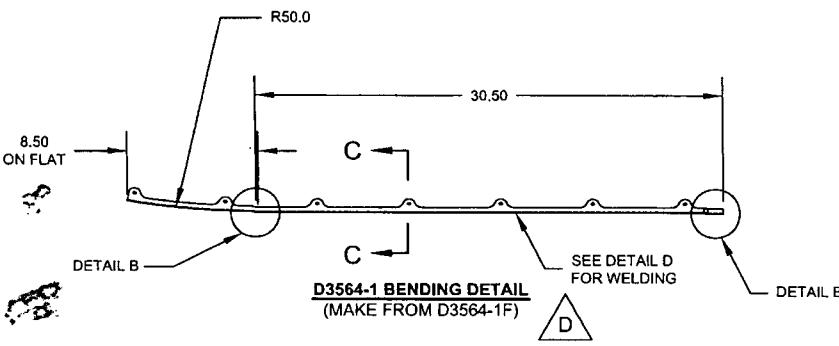
X First Article Prototype

Measured by:	<u>BB</u>	Audited by:	<u>/</u>	Prototype Approval:	N/A
Date:	<u>8-2-25</u>	Date:	<u>08.02.25</u>	Date:	N/A

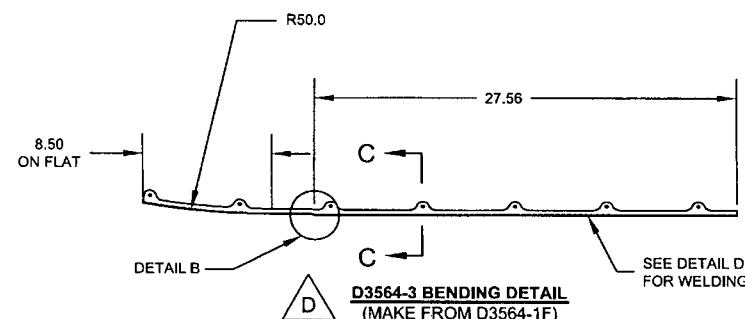
Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	
B	07.07.18	Dimensions updated per Dwg Rev. C	KJ/JLM	E



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

2010-2011 学年第一学期

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)

2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: SEE TABLE IN ZONE A3

8) WELD PER DART QSI 004

9) SEE PG 3 FOR SECTIONS AND DETAILS

10) PARTS ARE SYMMETRIC ABOUT C

RT QSI 005 4.3
D

NO 37561

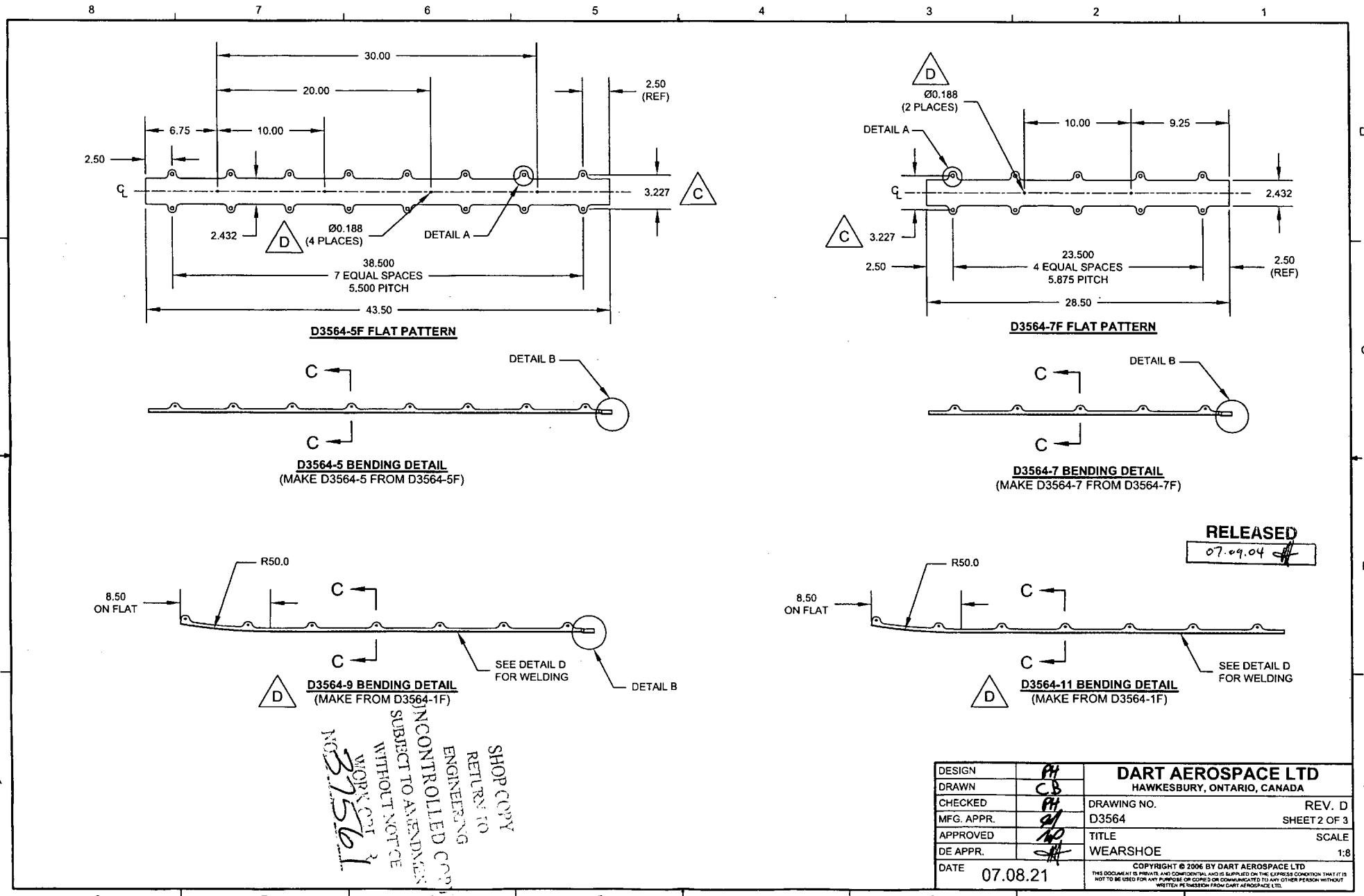
SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK OF DEPT.

<u>WEIGHTS:</u>	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

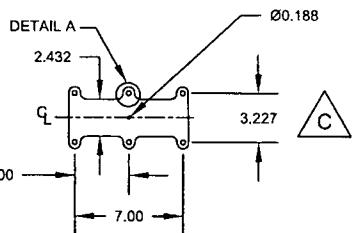
UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES;				
D	PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, T2: RELOCATE DETAILS AND SECTION; PG3 A5, T2: INCREASE DETAIL AND SECTION SIZE			
	CB	07.08.21		
	C	MOVE TAB OUTBOARD, DETAIL A		
	B	ADD AMS 5513 AND AMS 5524		
	A	NEW ISSUE		
	REV.	DESCRIPTION		BY DATE
	DESIGN	<i>PH</i>	DART AEROSPACE LTD	
	DRAWN	<i>CB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO. REV. D		
MFG. APPR.	<i>SI</i>	D3564 SHEET 1 OF 3		
APPROVED	<i>NO</i>	TITLE SCALE		
DE APPR.	<i>SI</i>	WEARSHOE 1:8		
DATE	07.08.21			

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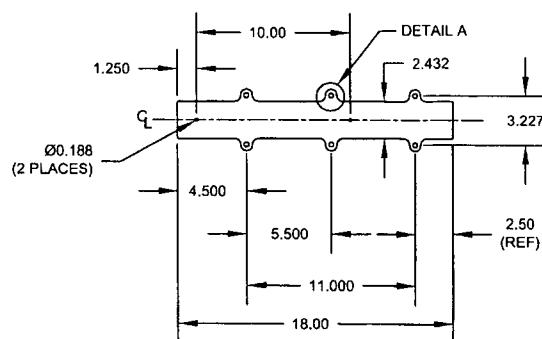
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8 1 7 1 6 5 4 3 2 1



D3564-13F FLAT PATTERN

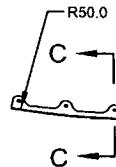


D3564-15F FLAT PATTERN

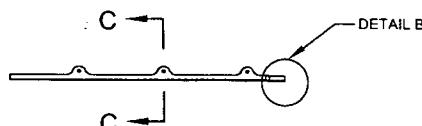
2059B HARDCOAT WELD 4.0 LONG 0.063 TO 0.125 HIGH
(11 PLACES)
WELD AFTER BENDING AS ILLUSTRATED PER DT8308



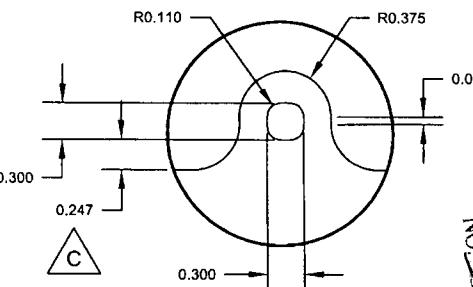
DETAIL D
(D3564-1/3-9/11 WELDING DETAIL)



D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)

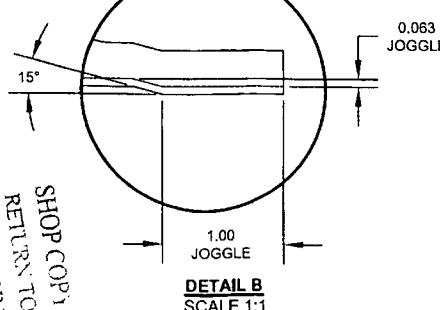


D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL A
SCALE 1:1

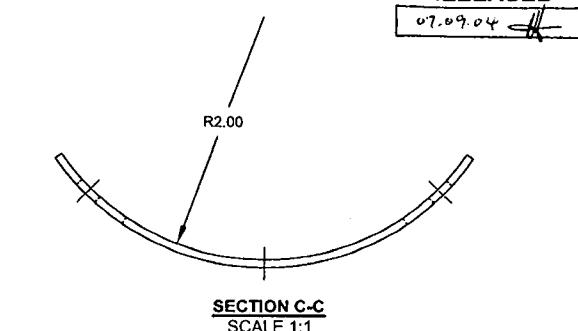
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WORK ORDER
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ENGINEERING



DETAIL B
SCALE 1:1

DESIGN	P4	DART AEROSPACE LTD
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	REV. D
MFG. APPR.	SI	DRAWING NO. D3564
APPROVED	SP	SHEET 3 OF 3
DE APPR.	SP	TITLE WEARSHOE
DATE	07.08.21	SCALE 1:8

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SECTION C-C
SCALE 1:1

8 1 7 1 6 5 4 3 2 1

8 1 7 1 6 5 4 3 2 1